

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025640**Date Inspected:** 04-Aug-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the Self-Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

SHIP # 19, OBG SEGMENT 14W (NWIT # 09868)

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

SEG3020AY-155, 160, 165

SEG3020AG-032

SEG3020K-161, 162, 164, 165

SHIP # 19, OBG SEGMENT 14E

This Quality Assurance Inspector (QA) performed Visual Testing (VT) review of randomly selected welds and base metal of Side Panel, Bottom Panel, Edge Panel and Deck Panel located on OBG segment 14E. The following issue(s) have been noted.

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Weld joint SEG3019N-325 joining top Anchorage Plate (AP) 3001A to Floor Beam (FB) 3263A at Panel Point (PP) 126.5 (W) observed as incomplete weld.

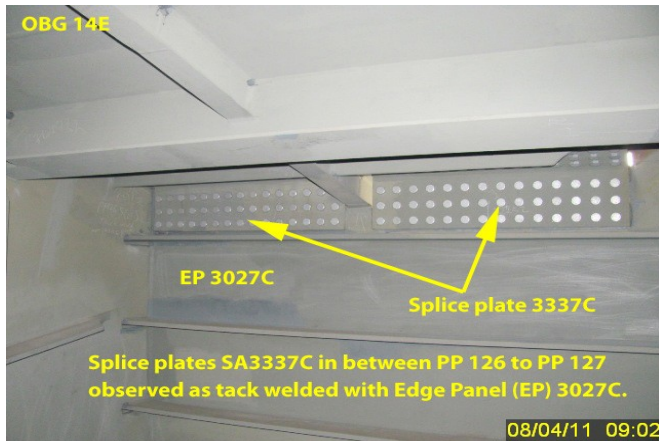
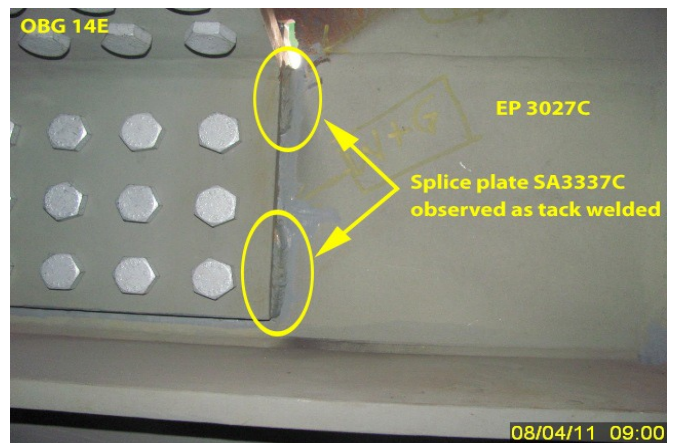
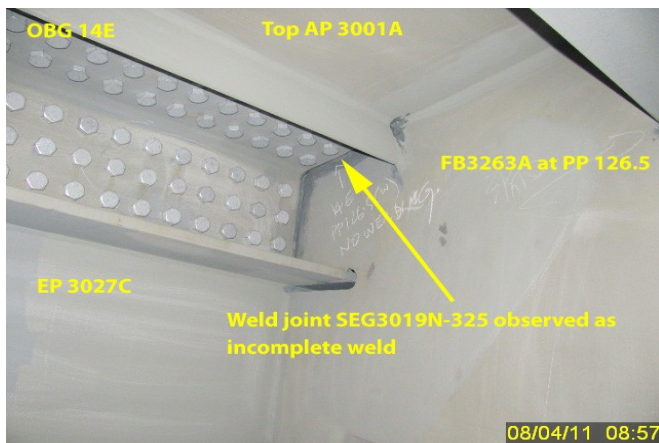
Splice plates SA3337C in between PP 126 to PP 127 observed as tack welded with Edge Panel (EP) 3027C.

Weld joint SEG3019S-284 joining FB 3263A to Longitudinal Diaphragm (LD) 3040A at PP 125.5 (W) observed as incomplete at cope hole area.

Stiffener on FB 3263A at PP 125.5 (E) observed as gouged approx 3mm deep, base metal repair need to be done.

See attached photographs for more details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

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Inspected By: Gaikwad,Umesh

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer